

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024914**Date Inspected:** 13-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

**Bay 9**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on cantilever truss assemblies. ZPMC QC inspector Zhu Zhong Jie was present at this time of this observation and informed this QA inspector of the work that is in process and identified Chen Shi Yang as the CWI. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BKSA12A5-001

WPS-B-T2231-ESAB

Welder- 062265, 059416

1G/FCAW/CJP (Fill pass weld)

**Bay 6**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding VT repairs on CB18 assembly. ZPMC CWI Li Yang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA

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## WELDING INSPECTION REPORT

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inspector verified this information for the following location;

Weld- CB3002A-018-018

WPS-B-T-2232-ESAB

Welder- 215248, 215397

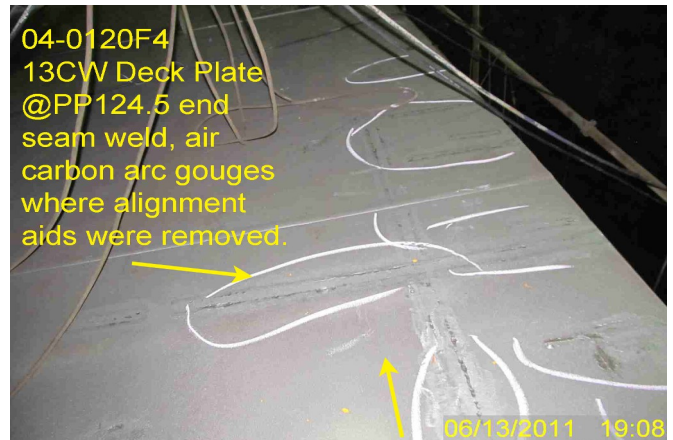
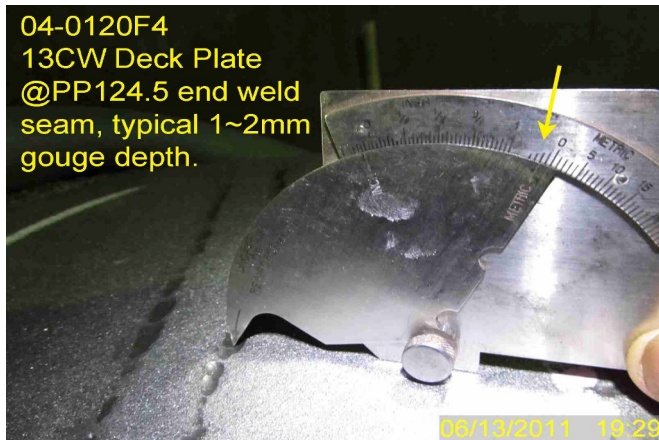
2G/FCAW

### Post Blast Inspection

QA performed visual inspection (VT) of exterior welds/surfaces on OBG Segments 13AW, 13BW, 13CW deck plate, Blast Shop 4. The VT inspection location was from the CB side edge plate to deck drip plate at architectural housing side, and end seam weld PP124.5 ~ PP117.5. At conclusion of the QA VT inspection, ABF QC was notified of the inspection results and verified the findings. However, no ZPMC QC present at the time of the post blast inspection. See QUALITY ASSURANCE – POST BLAST WELD REPAIR REPORT, dated 06-13-11 for additional information.

The following digital pictures illustrates deck plate end seam weld near PP124.5 where fit-up alignment aids were removed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

“As noted within the contents of this report.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

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**Inspected By:** Hasler, Mike

Quality Assurance Inspector

**Reviewed By:** Riley, Ken

QA Reviewer

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